

Work Order ID 126727

November-24-14 9:25:19 AM

Item ID: D350-591-113

Revision ID:

Item Name: Heli-Access Step™, Short, High Skid Gear C

Start Date: 11/24/14 Start Qty: 10.00

Required Date: 12/31/14 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

150	QC5- Inspect part completeness
-----	--------------------------------

150
QC

Quality Control

160	Chemical Conversion Coat per C
-----	--------------------------------

160
HandFinish

Hand Finishing

165

170	Large Fab
-----	-----------

170
Large Fab

Large Fab

Memo
1-Rivet as per Dwg
2-Inspect for foreign
3-Weld Aft end cap
A/R AL ROD
4-Grind end cap we

Work Order ID 126727

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Item ID: D350-591-113

Revision ID:

Item Name: Heli-Access Step™, Short, High Skid Gear Compatible

Start Date: 11/24/14 Start Qty: 10.00

Required Date: 12/31/14 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2310	D
DSI 9525	A

100	Document Control	0.00							
-----	------------------	------	--	--	--	--	--	--	--

100
DC

Doc.Control -USB or Paperwork Photocopy bluefile & type labels per PPP D350-591-113 CHG005

110	Large Fab	0.00							
-----	-----------	------	--	--	--	--	--	--	--

110
Large Fab

Large Fab
Memo
1-Cut D2244 extrusion to 62.00" long as per Dwg D2310
2-Drill extrusion as per Dwg D2310 using drill Jig DT8230
3-Deburr

slip Feb 15, 2015

350-591-113

B 126727

RECEIVED

126727

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

10X
FEB 02 2015
DAS
46
9-89

10X
DH 14/11/26

10X
J.C.L.
(Ø1.250 Hole)
14/12/02

1118 p. 4

1118

1118

1118

1118

1118

1118

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Item ID: D350-591-113

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Heli-Access Step™, Short, High Skid Gear Compatible

Start Date: 11/24/14 Start Qty: 10.00

10

Cust Item ID:

Required Date: 12/31/14 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00

180

QC

Memo

0.00

Quality Control

/0

JAN 26 2015

DAS
24
9-89

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

10

JAN 26 2015

DAS
24
9-89

200

Chemical Conversion Coat per QSI005 4.1

0.00

200

HandFinish

Memo

0.00

Hand Finishing

10

DAS
38
9-89

JAN 26 2015

Work Order ID 126727

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Item ID: D350-591-113 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Heli-Access Step™, Short, High Skid Gear Compatible
 Start Date: 11/24/14 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 12/31/14 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210 *210* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>m 129808</i> Memo START TIME: <i>11:40</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>12:10</i>	0.00 0.00				<i>10</i>	<i>15</i>	<i>1-28</i>	<i>238</i>
220 *220* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch <i>111309300</i> Memo	0.00				<i>10</i>	<i>15</i>	<i>1-28</i>	
230 *230* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>10</i>			

DAS
38
9-89

JAN 29 2015

Work Order ID 126727***126727***

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Item ID: D350-591-113

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Heli-Access Step™, Short, High Skid Gear Compatible

Stop ***NS2***Start Date: 11/24/14 Start Qty: 10.00 ***10***

Cust Item ID:

Required Date: 12/31/14 Req'd Qty: 10.00 ***10***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

270 QC21- Final Inspection - Work Order Release 0.00

270

QC

Memo

0.00

Quality Control

MLJ 15-02-03

ME

15-2-2

Picklist Print

November-24-14 9:25:18 AM

Page 1

Work Order ID: 126727

126727

Parent Item: D350-591-113

D350-591-113

Parent Item Name: Heli-Access Step™, Short, High Skid Gear Compatible

Start Date: 11/24/14

Required Date: 12/31/14

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:H04.11.09ReformatKJ/JLM
ECN10-586 10.06.18 DD verf:EC

IPP Rev:E as per

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116

Manufactured

No

110

Each

203.0000

1

10

D2244-116

STEP EXTRUSION

**

DL 14/11/26

Location

Loc Qty

Loc Code

HALL

138

117818

138

WA003

64.9999632

104940

56

60307

9

10

D2275

Manufactured

No

130

Each

63.0000

1

10

D2275

Bushing

**

CPC 14.12.9

Location

Loc Qty

Loc Code

WA003

63

103631

18

107673

25

108945

20

5

15

D2582

Manufactured

No

170

Each

18.0000

1

10

D2582

Hi-Skid Step Leg Ass'Y

**

Dh 15/1/20

Location

Loc Qty

Loc Code

WA003

18

106091

1

111490

1

121022

16

3127837 → 8

12

Picklist Print

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Page 2

Work Order ID: 126727

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Parent Item: D350-591-113

D350-591-113

Parent Item Name: Heli-Access Step™, Short, High Skid Gear Compatible

Start Date: 11/24/14

Required Date: 12/31/14

Start Qty: 10.00

Required Qty: 10.00

D2673-34

Manufactured No

130

Each

25.0000

2

20

D2673-34

End Plate

**

Location

Loc Qty

Loc Code

WA003

~~117775~~
117775

25

21

4

240

Each

0.0000

1

10

K591-113

DAS

Manufactured No

K591-113

46

Short Step Instln

9-89

**

MS20600-AD4W3

Purchased No

170

Each

1,191.000

16

160

MS20600-AD4W3

Cherry Rivets

**

Location

Loc Qty

Loc Code

CCK004

600

m129795

600

ST309

524

m130018

524

WA003

67

m127476

7

m129278

60

Cx 14-12-9
B117775 → 4
B127168 → 16
126730
DAS 9-89
DL 15/1/20

160



DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2310	REV. D SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH SHORT STEP ASSEMBLY	SCALE NTS
A	94.11.10	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	05.11.14	UPDATE FINISHING NOTE	

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

Part No.	Description	QTY
D2310	High Short Step Assembly	X
D2244-62.0	STEP EXTRUSION*	1
D2275	BUSHING	1
D2582	STEP LEG ASSEMBLY	1
D2673-34	STEP END PLATE	2
MS20600AD4W3	Rivets	16

*cut per drawing

122222
122222
122222

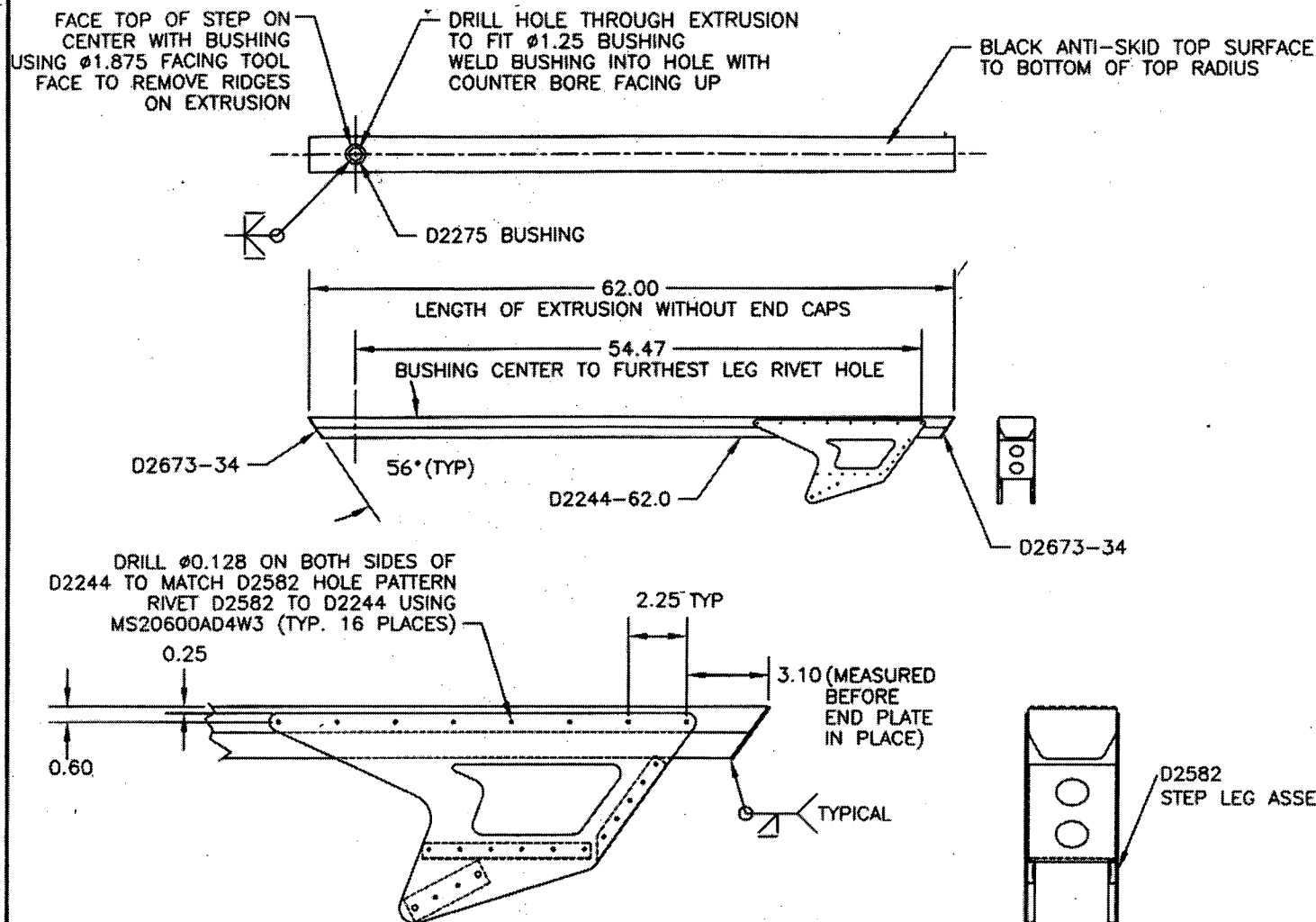
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05.11.28

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DESIGN	KE	DRAWN BY	PH	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.11.14	DRAWING NO.	D2310	REV. D
		TITLE	HIGH SHORT STEP ASSEMBLY	SHEET 2 OF 2
		SCALE	NTS	



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.28